

5/13

~~SECRET~~

DART AEROSPACE LTD	Work Order:	22526B
Description: STA 155 bracket	Part Number:	D2804-2
Dwg: D2804 rev. A1 ^{04.08.06} AS ^{BQ} _{05.02.21}	Qty:	20

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	HA	05.02.23	20
2	METAL	Cut blanks per template DT8534 Material: 6061-T6 bar 10.00" x 0.50" thick plate 1116753 ¹¹¹⁶⁷⁵³ Batch: 1116753	J	05.03.08	20
3	HAAS	Machine as per folio FA103	BE	05.03.10	20
4	QC	Inspect Level 2	BE	05.03.10	20
5	QC	Inspect Level 8	ML	05.03.10	20
6	METAL	Tumble & Deburr	BE	05.03.10	20
7	QC	Inspect Level 5	ML	05.03.10	20
8	FINISHING	Chemical conversion coat per QSI 005	CPL	05.03.21	20
9	STORES	Identify and stock	ML	05.03.22	20
10	EXPEDITING	Close W/O Cost / part: 35.85 ^{38.39} Suc 05/02/28 (20)	HA	05.04.05	20

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	

RELEASED

EC 00.11.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22526
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804	Rev: A+B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.130	✓			
0.125	+/-0.010	0.135	✓			
R0.125	+/-0.010	R.125	✓			
0.250	+/-0.010	0.252	✓			
0.250	+0.000/-0.005	0.248	✓			
0.875	+0.000/-0.001	0.8744	✓			
R0.062	+/-0.010	R.062	✓			
Ø0.757	+0.005/-0.000	Ø.757	✓			
R0.625	+/-0.010	R.625	✓			
12.304	+/-0.005	12.300	✓			
Ø0.507	+0.000/-0.001	Ø.507	✓			
0.437	+0.000/-0.001	0.437	✓			can't measure accurately
0.608	+0.000/-0.001	0.608	✓			" " "
Ø0.191	+0.005/-0.000	Ø.191	✓			
1.420	+0.001/-0.001	1.420	✓			
0.250 deep	+/-0.010	0.242	✓			
6.933	+/-0.005	6.935	✓			
7.578	+/-0.005	7.576	✓			
0.500	+/-0.010	0.501	✓			

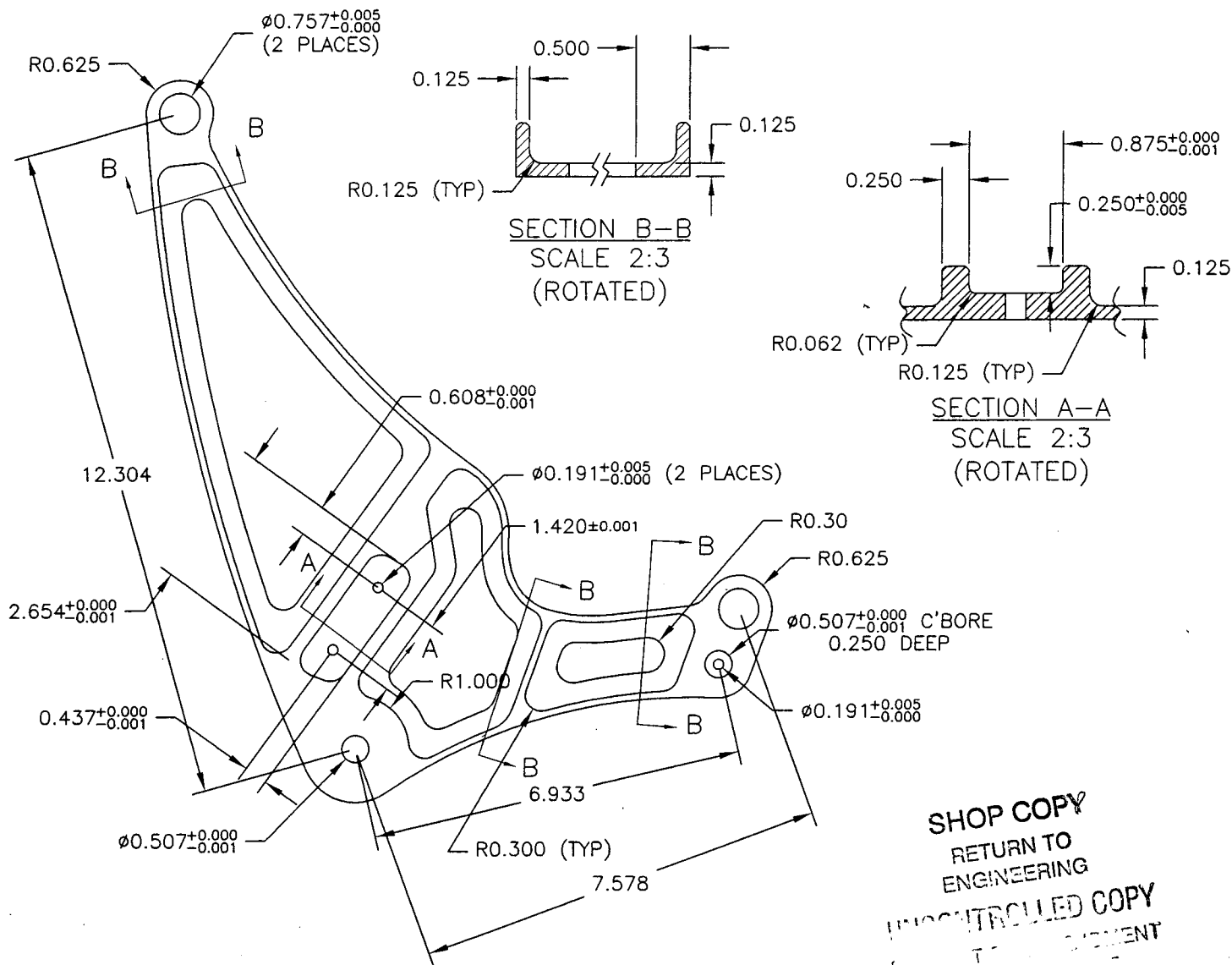
Measured by: <i>EC</i>	Audited by: <i>gm</i>	Prototype Approval:	N/A
Date: 05.03.09	Date: 05/03/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	

RELEASED
21/07/12

PRELIMINARY ISSUE

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2804	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	



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DATE

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 22, 2005
03:39 pm

Work Order No : 0022526
Project Name : D2804-2
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D2804-2
Description : STA 155 Bracket
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 02-22-05
Est Finish Date : 03-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00